

Work Order ID 77757

\*77757\*

Page 1

December-21-11 8:24:26 AM

Item ID: D350-636-012

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 21/12/2011 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 09/01/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/12/21

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750	F								
D3492	C								

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

W 12 02 02 ①  
H for M.L.J 12-1-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 77757****\*77757\***

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December-21-11 8:24:26 AM

Item ID: D350-636-012

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 21/12/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 09/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00

**\*110\***

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 &amp; DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

12/01/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 77757**

December-21-11 8:24:26 AM

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Item ID: D350-636-012

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 21/12/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 09/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004A/R Aluminum Rod batch: *M119712**BE 12-01-09*

12-Grind welds flush as per Dwg D2750

*BB 12/01/09*

120

QC10- Inspect visual per QSI004- ground welds 0.00

**\*120\***

QC

Memo

0.00

*812601/09*

Quality Control

130

QC5- Inspect part completeness to step on W/O 0.00

**\*130\***

QC

Memo

0.00

*812601/09*

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**\*77757\***

December-21-11 8:24:26 AM

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Cust Item ID:**

**Start Date:** 21/12/2011    **Start Qty:** 1.00

**\* 1 \***

**Required Date:** 09/01/2012      **Req'd Qty:** 1.00

**\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 21/12/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 09/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
<b>*160*</b>									
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3-Open float holes to .500" (4 per Side)								
	4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5-Deburr and blow out all chips from inside of tube								
	6-Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per OSI 015 A/R Sikaflex-291 batch: <u>119506</u> exp. date: <u>12-01-13</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: <u>M119712</u>								
	9- At section AP-AP drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750 <u>7 mo 12/1/11</u>								
	11-Spot face ground handling holes section (total of 4 places per side) as per								

*Handwritten notes and signatures:*  
A large checkmark is drawn over the table content.  
Signature: BB  
Date: 12/01/10

*Handwritten notes:*  
Signature: BB  
Date: 12-01-13

*Handwritten notes:*  
Signature: BB  
Date: 12/01/11

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

Work Order ID 77757

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December-21-11 8:24:26 AM

Item ID: D350-636-012

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 21/12/2011 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 09/01/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*


QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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dwg D2750

12-Deburr holes

 12/01/23

170

QC10- Inspect visual per QSI004- ground welds

0.00


\*170\*

QC

Memo

0.00

Quality Control

 12/01/23

180

QC5- Inspect part completeness to step on W/O

0.00


\*180\*

QC

Memo

0.00

Quality Control

 12/01/23



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 77757

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December-21-11 8:24:26 AM

Item ID: D350-636-012

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 21/12/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 09/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190 Pressure Wash per QSI005 4.3

0.00

**\*190\***

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

*1X M-12/01/23*

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*200\***

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

210

QC3- Inspect Part Finish

0.00

**\*210\***

QC

Quality Control

Memo

Inspect for foreign object per QSI 024

0.00

*1X M-12/01/23*

*1 BR 12-1-26*

*M119480*

*1-15  
320 OF  
1-45*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

Work Order ID 77757

\*77757\*

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December-21-11 8:24:26 AM

Item ID: D350-636-012

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 21/12/2011 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 09/01/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
*230*	HandFinish	0.00							
Hand Finishing	Memo								
	1-Install inserts as per dwg D2750								
	2-Inspect for Foreign Objects								
	3-Spray inside of tube with "LPS-3" batch: <u>N/A</u>								
	4-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>119508</u> EXP DATE: <u>12-8</u>								
	5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>10348</u>								
	6-Coat all exposed fasteners with "LPS Procyon" batch: <u>114596</u>								

1 BL 12-1-26

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**Work Order ID 77757****\*77757\***

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December-21-11 8:24:26 AM

Item ID: D350-636-012

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 21/12/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 09/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
<b>*240*</b>									
QC	Memo	0.00							
Quality Control									
250	Pick Kit	0.00							
<b>*250*</b>									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
<b>*260*</b>									
QC	Memo	0.00							
Quality Control									

S 176130

S7 12-02-02.

wl 12-02-02 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID 77757

\*77757\*

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December-21-11 8:24:26 AM

Item ID: D350-636-012 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Skidtube RH  
 Start Date: 21/12/2011 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 09/01/2012 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Packaging	0.00							
*270*									
Packaging	Memo	0.00	Reo						
Packaging	Package as per PPP D350-636-012								
280	QC21- Final Inspection - Work Order Release	0.00							
*280*									
QC	Memo	0.00							
Quality Control									

ME  
12-02-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

December-21-11 8:24:30 AM

Page 1

Work Order ID: 77757

**\*77757\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 21/12/2011

Required Date: 09/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:102.09.25Rearranged procedure stepsKJ  
 IPP Rev:J 06-03-29 As per Rev D EC  
 IPP Rev:K 06-07-13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC  
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O  
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as  
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-3-BENT

Manufactured No

110

Each

26.0000

1

1

**\*D2600-3-BFNT\***

Extrusion Bent

\*\*

① 12/01/08

Location

Loc Qty

Loc Code

LG

26

66875

7

73253

1

75021

1

75022

1

75023

1

77623

15

D2744

Manufactured No

110

Each

34.0000

1

1

**\*D2744\***

Cap

\*\*

BF12-01-09

Location

Loc Qty

Loc Code

LG002

34

62715

1

70881

12

71861

21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

December-21-11 8:24:30 AM

Work Order ID: 77757

**\*77757\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 21/12/2011

Required Date: 09/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2739 Manufactured No

160 Each 4.0000 1 1

**\*D2739\***

350 I Beam

77621

\*\*

21 12-01-11

Location

Loc Qty

Loc Code

LG

4

72155

1

76987

3

D2743 Manufactured No

160 Each 169.0000 8 8

**\*D2743\***

Crossbolt Spacer

\*\*

BE 12-01-13

Location

Loc Qty

Loc Code

LG001

169

67766

4

68251

3

73403

64

74445

92

76141

6

8

D3490-3 Manufactured No

160 Each 22.0000 4 4

**\*D3490-3\***

Cross Bolt Spacer

\*\*

BE 12-01-13

B77567 x2

Location

Loc Qty

Loc Code

LG001

22

74877

22

2

D3490-1 Manufactured No

160 Each 30.0000 4 4

**\*D3490-1\***

Cross Bolt Spacer

\*\*

BE 12-01-13

Location

Loc Qty

Loc Code

LG001

30

62450

2

67773

4

74875

24

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

December-21-11 8:24:30 AM

Work Order ID: 77757

**\*77757\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 21/12/2011

Required Date: 09/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3631-1 Manufactured No

230 Each 399.0000 8 8

**\*D3631-1\***

Washer

\*\*

*Bl 12-1-26*

Location

Loc Qty

Loc Code

ST072

399

68062

2

75548 ✓

397

*8*

D3791-1 Manufactured No

230 Each 25.0000 1 1

**\*D3791-1\***

Wearplate

\*\*

*Bl 12-1-26*

Location

Loc Qty

Loc Code

FP002

25

62239

2

74598

7

75041 ✓

16

*1*

D3793-3 Manufactured No

230 Each 18.0000 1 1

**\*D3793-3\***

Wearshoe

\*\*

*Bl 12-1-26*

Location

Loc Qty

Loc Code

FP001

18

74528

5

74593

1

75043 ✓

12

*1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

December-21-11 8:24:30 AM

Work Order ID: 77757

**\*77757\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 21/12/2011

Required Date: 09/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS21043-6

Purchased

No

230

Each

401.0000

4

4

**\*MS21043-6\***

NUT

\*\*

*BL 12-1-26*

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

381

112314 ✓

171

117887

10

118384

200

*4.*

D3794-1

Manufactured

No

230

Each

35.0000

1

1

**\*D3794-1\***

Gasket

\*\*

*BL 12-1-20*

Location

Loc Qty

Loc Code

FP002

35

74594

7

75042 ✓

28

*1*

NAS1611-010

Purchased

No

230

Each

135.0000

8

8

**\*NAS1611-010\***

O-RING

\*\*

*BL 12-1-26*

Location

Loc Qty

Loc Code

FP001

135

110915

14

117460

8

118077

1

118612

3

119438

59

119623

50

*8.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

December-21-11 8:24:30 AM

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Work Order ID: 77757

**\*77757\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 21/12/2011

Required Date: 09/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250

Each

21.0000

1

1

**\*D2741\***

Blade, 350 Skidtube

\*\*

SP 12-02-02.

Location

Loc Qty

Loc Code

ST

-8

71856

2

ST466

29

71856

19

NAS1515H3L

Purchased

No

230

Each

107.0000

4

4

**\*NAS1515H3I \***

WASHER

\*\*

BR 12-1-20.

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

67

118686

3

119438

64

NAS1611-013

Purchased

No

230

Each

128.0000

8

8

**\*NAS1611-013\***

O-RING

\*\*

BR 12-1-20.

Location

Loc Qty

Loc Code

FP001

128

116582

5

117291

2

117887

53

119307

24

119438

2

119623

42

8.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

December-21-11 8:24:30 AM

Work Order ID: 77757

**\*77757\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 21/12/2011

Required Date: 09/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 250.0000 4 4

**\*AN3C6A\***

BOLT

\*\*

*BL 12-1-26*

Location	Loc Qty	Loc Code
FP001	1	
111982	1	
ST351	249	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	13	
119449	100	
119749	81	

NAS1149C0832R Purchased No 230 Each 326.0000 1 1

**\*NAS1149C0832R\***

WASHER

\*\*

*BL 12-1-26*

Location	Loc Qty	Loc Code
ST297	326	
114915	326	

D3536-25 Manufactured No 230 Each 23.0000 1 1

**\*D3536-25\***

Gasket

\*\*

*BL 12-1-26*

Location	Loc Qty	Loc Code
FP002	23	
75039	23	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

December-21-11 8:24:30 AM

Work Order ID: 77757

**\*77757\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 21/12/2011

Required Date: 09/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-3 Manufactured No

230 Each 17.0000 1 1

**\*D3794-3\***

Gasket

\*\*

*PR 12-1-26*

Location

Loc Qty

Loc Code

FP002

17

74530

3

74596 ✓

14

AN3C5A Purchased No

230 Each 1,046.000 34 34

**\*AN3C5A\***

Bolt

\*\*

*BR 12-1-26*

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1039

116419

28

117343

17

117764

49

117872

2

119127 ✓

500

119749

443

D3537-1 Manufactured No

230 Each 56.0000 3 3

**\*D3537-1\***

Wearpad

\*\*

*PR 12-1-26*

Location

Loc Qty

Loc Code

FP002

56

69817

5

74867

51

*3.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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December-21-11 8:24:31 AM

Work Order ID: 77757

**\*77757\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 21/12/2011

Required Date: 09/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25 Manufactured No

230 Each 21.0000 1 1

**\*D3535-25\***

Wearshoe

\*\*

BR 12-1-26

Location

Loc Qty

Loc Code

FP001

21

62233

1

74592

8

75040

12

D3492-3 Manufactured No

230 Each 61.0000 8 8

**\*D3492-3\***

Plug

\*\*

BR 12-1-26

\* 3492-013

Location

Loc Qty

Loc Code

FP002

61

74447

17

74871

44

AN960C10L ~~R~~ WAS1149C0332 Purchased No

230 Each 0.0000 38 38

**\*AN960C10I \***

washer

\*\*

38 BR 12-1-26

114736

D3488-042 Manufactured No

230 Each 17.0000 1 1

**\*D3488-042\***

Blade Fitting Assembly, RH

\*\*

BR 12-1-26

Location

Loc Qty

Loc Code

FP002

17

62003

1

69904

2

71883

3

75068

11

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

December-21-11 8:24:31 AM

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Work Order ID: 77757

**\*77757\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 21/12/2011

Required Date: 09/01/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

1,348.000

38

38

**\*AI S4-1032-225\***

Insert

\*\*

*BR 12-1-26*

Location

Loc Qty

Loc Code

ST281

1348

108696

199

110768

62

118386 ✓

858

118966

229

*38*

D3492-1

Manufactured

No

230

Each

110.0000

8

8

**\*D3492-1\***

Plug

\*\*

*BR 12-1-26*

Location

Loc Qty

Loc Code

FP002

110

69531

8

74444

2

76235 ✓

100

*8*

D3793-1

Manufactured

No

230

Each

14.0000

1

1

**\*D3793-1\***

Wearshoe

\*\*

*BR 12-1-26*

Location

Loc Qty

Loc Code

FP001

14

74591

2

75038 ✓

12

*1*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

December-21-11 8:24:31 AM

Work Order ID: 77757

**\*77757\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 21/12/2011

Required Date: 09/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C35A Purchased No

230 Each 87.0000 1 1

**\*AN8C35A\***

BOLT

\*\*

*BR 12-1-26*

Location	Loc Qty	Loc Code
FP002	86	
115960	1	
117834 ✓	29	<i>1</i>
118286	56	
ST346	1	
114442	0	
115188	0	
115960	1	

MS21083C8 Purchased No

230 Each 60.0000 1 1

**\*MS21083C8\***

NUT

\*\*

*BR 12-1-26*

Location	Loc Qty	Loc Code
FP002	1	
115884	1	
ST303	59	
115884	0	
118077	1	
118614 ✓	17	<i>1</i>
119309	2	
119436	25	
119638	14	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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December-21-11 8:24:31 AM

Work Order ID: 77757

**\*77757\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 21/12/2011

Required Date: 09/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

137.0000

8

8

**\*D2745\***

Bushing

\*\*

*BR 12-1-26*

Location

Loc Qty

Loc Code

FP001

137

69529

1

74446

36

76142 ✓

100

*8*

AN6C44A

Purchased

No

230

Each

59.0000

4

4

**\*AN6C44A\***

BOLT

\*\*

*BR 12-1-26*

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

57

118985

27

119125 ✓

30

*4*

D3532-1

Manufactured

No

250

Each

30.0000

2

2

**\*D3532-1\***

Spacer

\*\*

*SP 12-02-02*

Location

Loc Qty

Loc Code

ST065

30

74880

30

*24*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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December-21-11 8:24:31 AM

Work Order ID: 77757

**\*77757\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 21/12/2011

Required Date: 09/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

60.0000

2

2

**\*MS21083C8\***

NUT

\*\*

*m/20/142 SP.*

Location

Loc Qty

Loc Code

FP002

1

115884

1

ST303

59

115884

0

118077

1

118614

17

119309

2

119436

25

119638

14

NAS1149D0863J

Purchased

No

250

Each

173.0000

2

2

**\*NAS1149D0863.1\***

WASHER

\*\*

*SP*

Location

Loc Qty

Loc Code

ST298

173

~~118078~~

73

119307

100

*2x*

D3493-1

Manufactured

No

250

Each

29.0000

2

2

**\*D3493-1\***

Washer

\*\*

*SP. 12-02-02.*

Location

Loc Qty

Loc Code

ST062

29

70697

2

71846

1

76237

26

*2x*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

December-21-11 8:24:31 AM

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Work Order ID: 77757

**\*77757\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 21/12/2011

Required Date: 09/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

43.0000

2

2

**\*AN8C21A\***

BOLT

\*\*

SP 12-02-02.

Location

Loc Qty

Loc Code

ST343

43

118758

13

119530

30

2x

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).  
FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WITHOUT NOTICE  
 WORK ORDER  
 NO 77757 M.C.J  
 11/12/21

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 68 07 22 14

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515HBL; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	RAH		
CHECKED	LL	DRAWING NO.	REV. F
MFG. APPR.	LL	D2750	SHEET 1 OF 11
APPROVED	LL	TITLE	SCALE
DE APPR.	LL	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

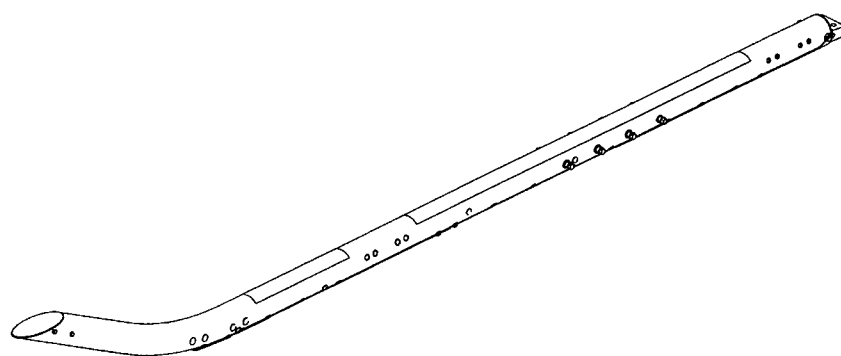
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

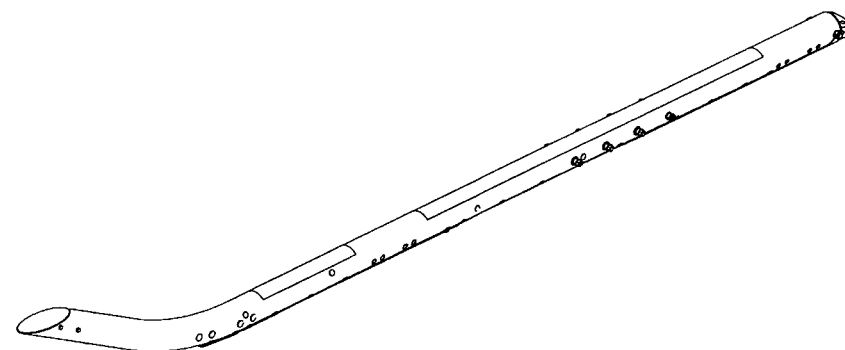
**NOTE:** Date & initial all entries



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D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

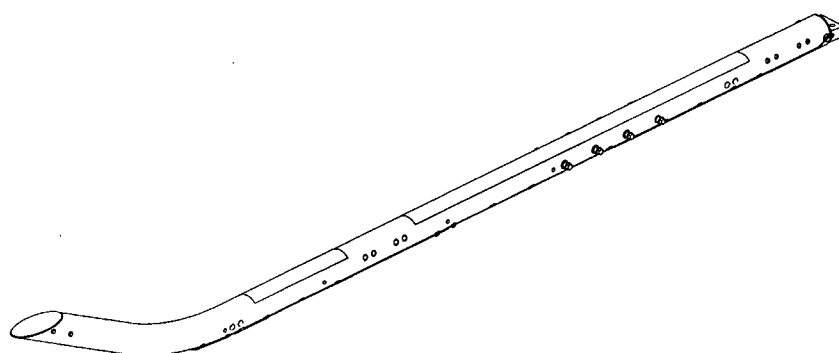
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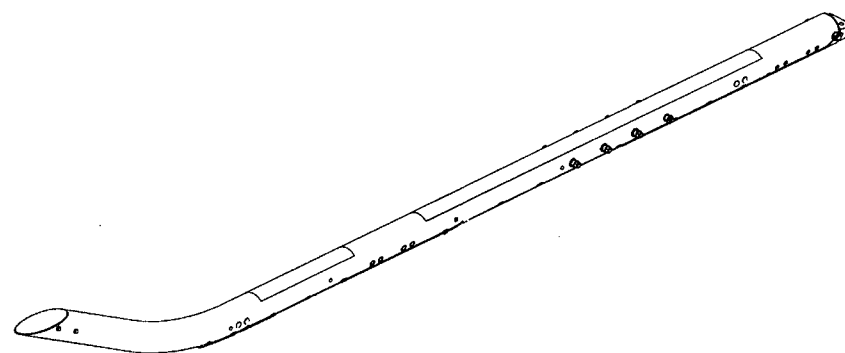
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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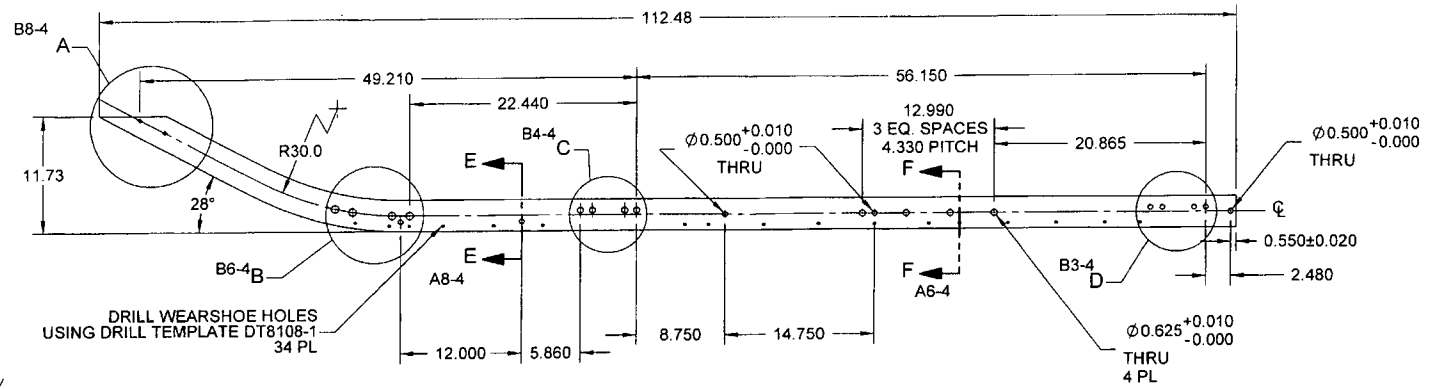
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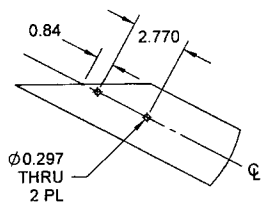
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

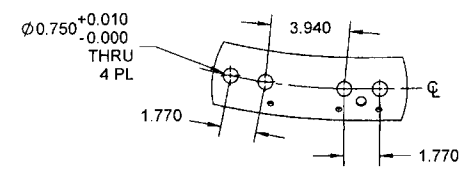
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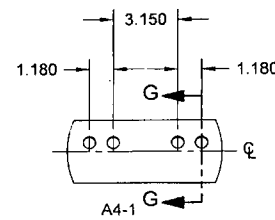
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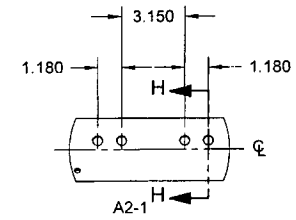
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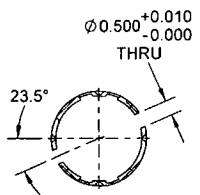
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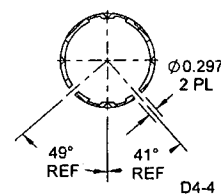
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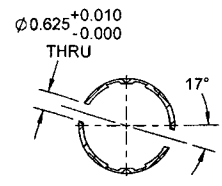
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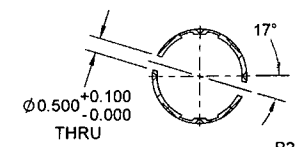
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

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MFG. APPR.		SHEET 4 OF 11	
APPROVED		TITLE	SCALE
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

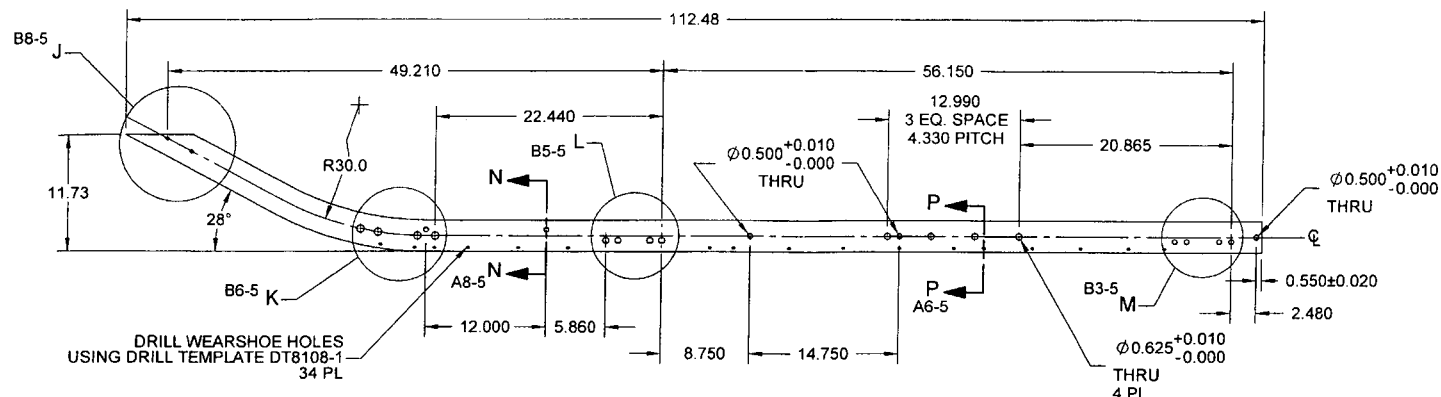
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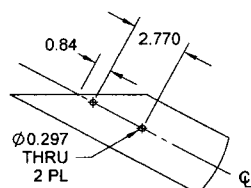
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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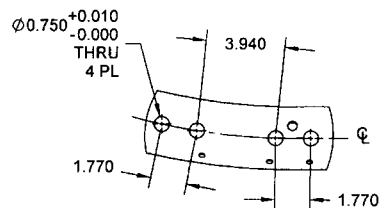
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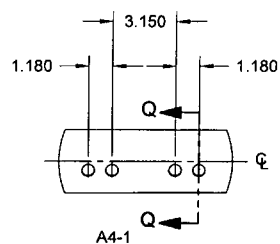
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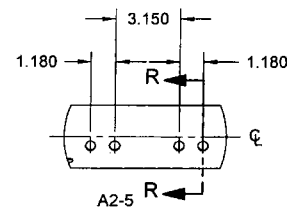
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SCALE 2X



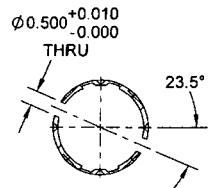
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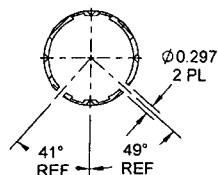
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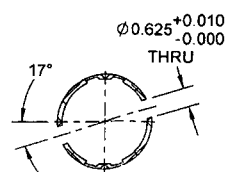
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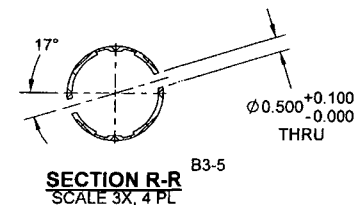
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

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MFG. APPR.		D2750	SHEET 5 OF 11
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

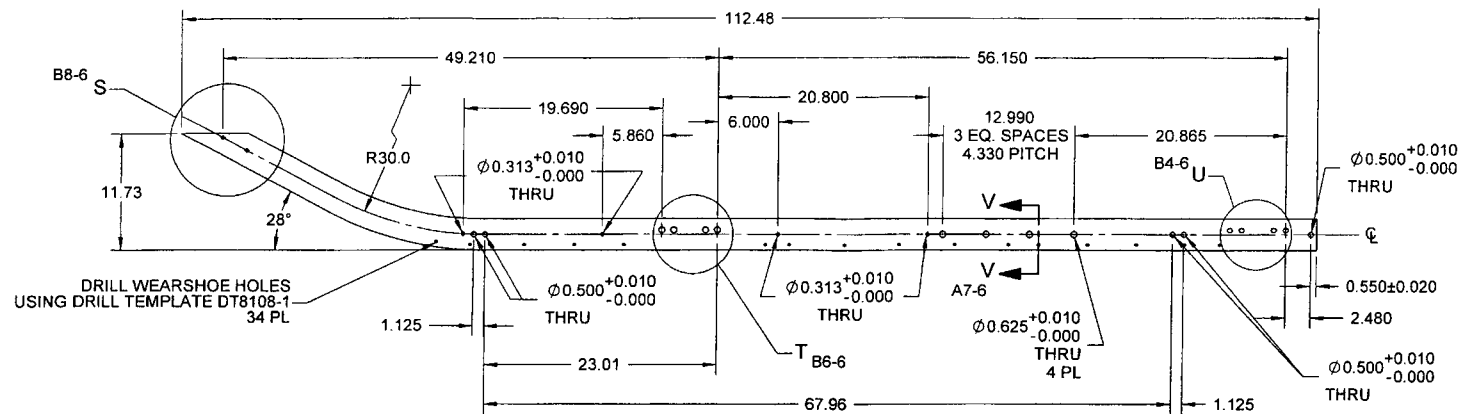
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

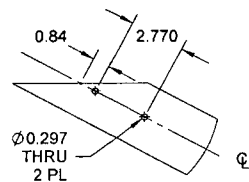
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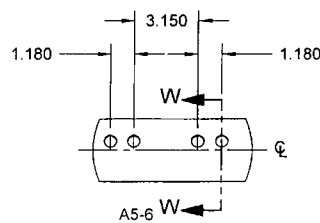
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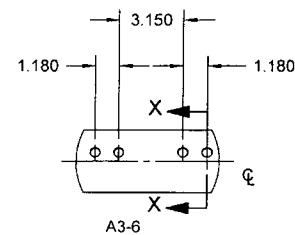
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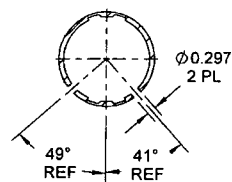
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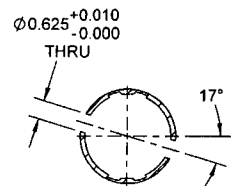
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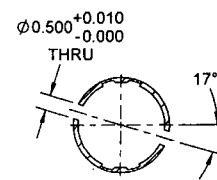
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**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

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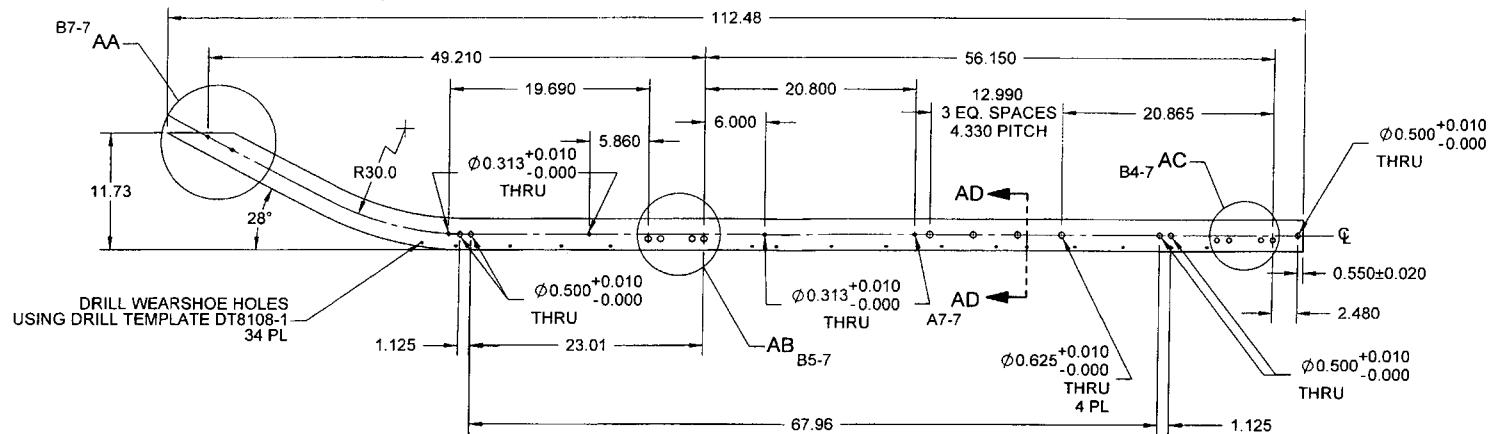
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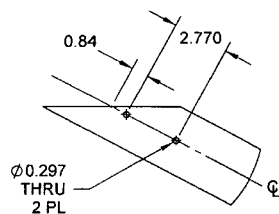
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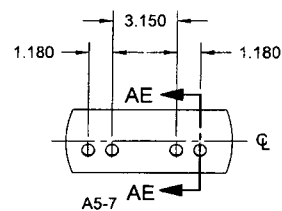
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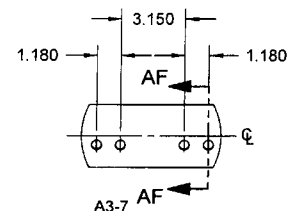
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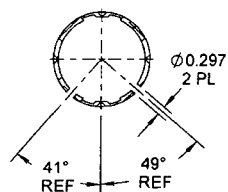
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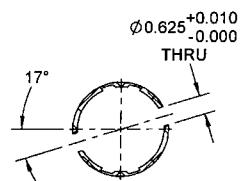
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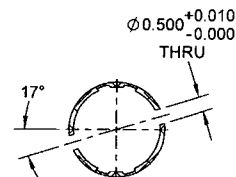
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL









**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

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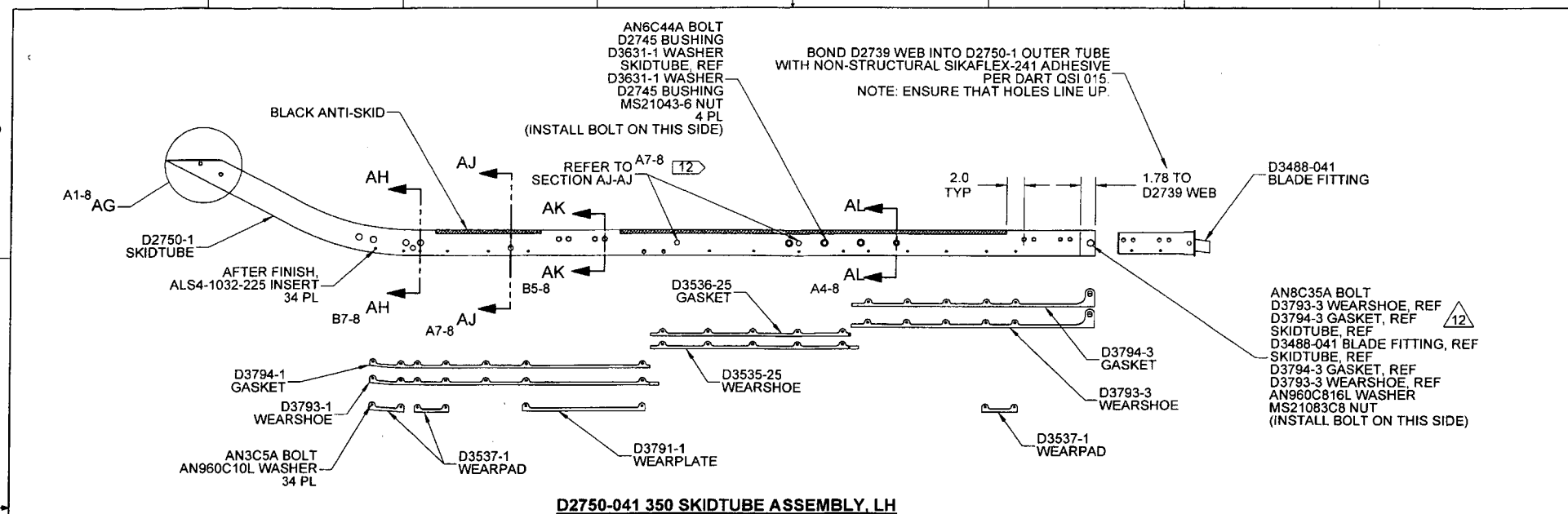
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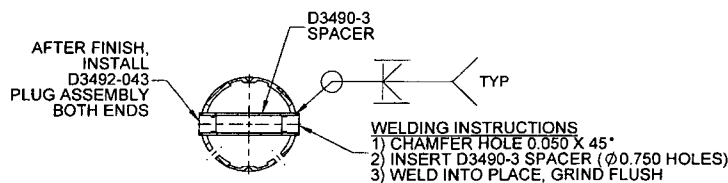
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**NOTE:** Date & initial all entries

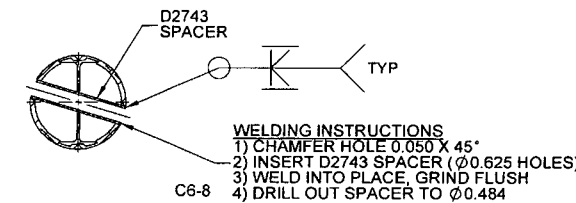
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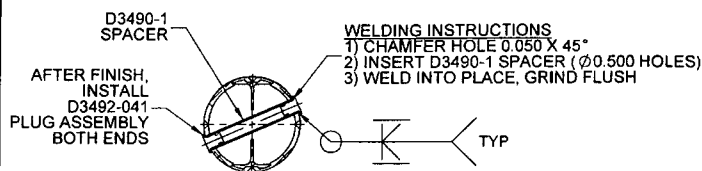
**D2750-041 350 SKIDTUBE ASSEMBLY, LH**



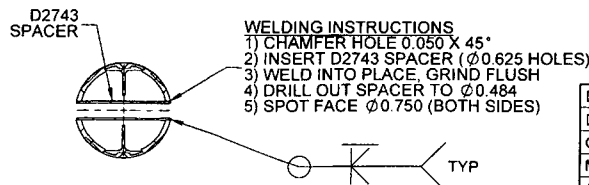
**SECTION AH-AH**  
SCALE 3X, 4 PL



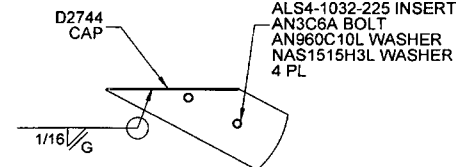
**SECTION AK-AK**  
SCALE 3X, 4 PL



**SECTION AJ-AJ**  
SCALE 3X, 4 PL



**SECTION AL-AL**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**DETAIL AG**  
SCALE 2X  
**RELEASED**

DESIGN	PA	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED		DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.		TITLE	SHEET 8 OF 11
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	SCALE
DATE	08.07.16		NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

AN6C44A BOLT  
D2745 BUSHING  
D3631-1 WASHER  
SKIDTUBE, REF  
D3631-1 WASHER  
D2745 BUSHING  
MS21043-6 NUT  
4 PL  
(INSTALL NUT ON THIS SIDE)

BOND D2739 WEB INTO D2750-2 OUTER TUBE  
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE  
PER DART QSI 015  
NOTE: ENSURE THAT HOLES LINE UP.

A1-9 AM

BLACK ANTI-SKID

REFER TO SECTION AP-AP

A7-9 13

2.0 TYP

1.78 TO D2739 WEB

D3488-042 BLADE FITTING

D2750-2 SKIDTUBE

AFTER FINISH, ALS4-1032-225 INSERT 34 PL

AN AN AP AQ AR

B7-9 A7-9 B5-9 A5-9

D3794-1 GASKET

D3793-1 WEARSHOE

AN3C5A BOLT  
AN960C10L WASHER  
34 PL

D3537-1 WEARPAD

D3791-1 WEARPLATE

D3536-25 GASKET

D3535-25 WEARSHOE

D3794-3 GASKET

D3793-3 WEARSHOE

D3537-1 WEARPAD

AN8C35A BOLT  
D3793-3 WEARSHOE, REF  
D3794-3 GASKET, REF  
SKIDTUBE, REF  
D3488-042 BLADE FITTING, REF  
SKIDTUBE, REF  
D3794-3 GASKET, REF  
D3793-3 WEARSHOE, REF  
AN960C816L WASHER  
MS21083C8 NUT  
(INSTALL NUT ON THIS SIDE)

Diagram illustrating the assembly of a plug assembly (D3492-043) into a hole, showing the installation of a D3490-3 spacer and the resulting weld joint.

**Labels:**

- AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY BOTH ENDS
- D3490-3 SPACER
- TYP

**WELDING INSTRUCTIONS:**

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D3490-3 SPACER ( $\varnothing 0.750$  HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH

D2743 SPACER

TYP

WELDING INSTRUCTIONS

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D2743 SPACER (Ø 0.625 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH
- 4) DRILL OUT SPACER TO Ø 0.484

AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY BOTH ENDS

WELDING INSTRUCTIONS

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D3490-1 SPACER (Ø 0.500 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH

1.000

TYP

**D2743 SPACER**

**WELDING INSTRUCTIONS**

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D2743 SPACER (Ø 0.625 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH
- 4) DRILL OUT SPACER TO Ø 0.484
- 5) SPOT FACE Ø 0.750 (BOTH SIDES)

**TYP**

D2744  
CAP

1/16" G

AFTER FINISH,  
INSTALL  
ALS4-1032-225 INSERT  
AN3C6A BOLT  
AN980C10L WASHER  
NAS1515H3L WASHER  
4 PL

EASED  
1/22/80

DESIGN	REV	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA  DRAWING NO. <b>D2750</b>  TITLE <b>350 SKIDTUBE ASSEMBLY</b>  COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	REV. F
DRAWN	REV		SHEET 9 OF 11
CHECKED			SCALE
MFG. APPR.			NTS
APPROVED			
DE APPR.			
DATE	08.07.16		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

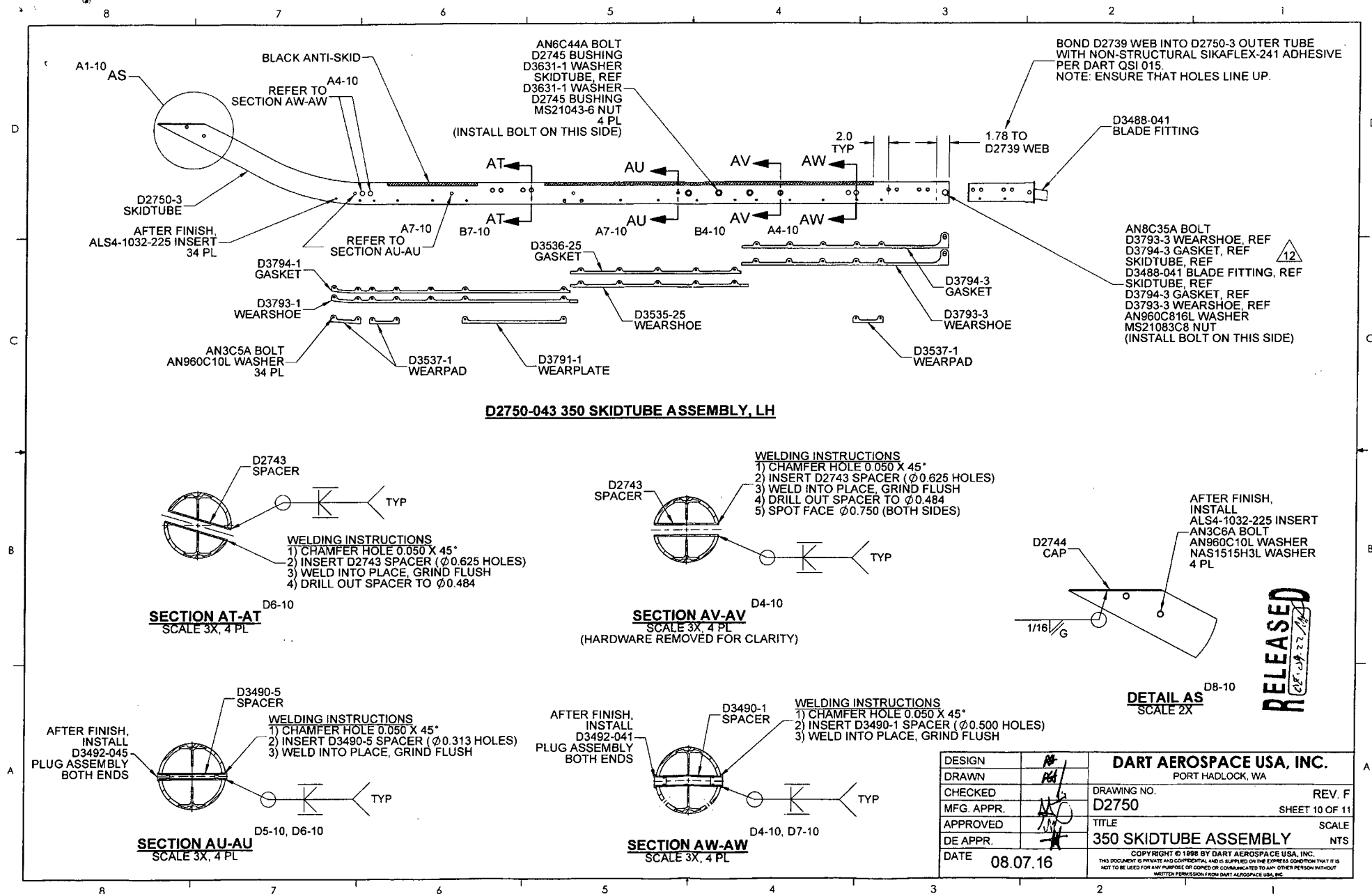
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



77757



DESIGN		<b>DART AEROSPACE USA, INC.</b>	
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CHECKED		DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.		SHEET 10 OF 11	
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	
DATE	08.07.16	NTS	

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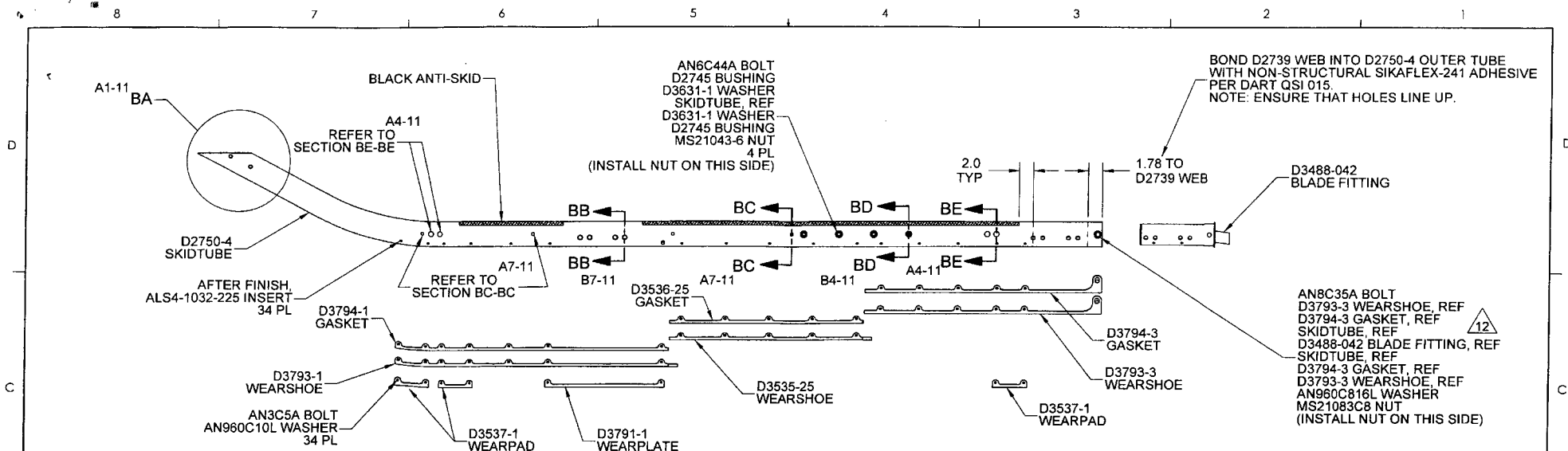
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

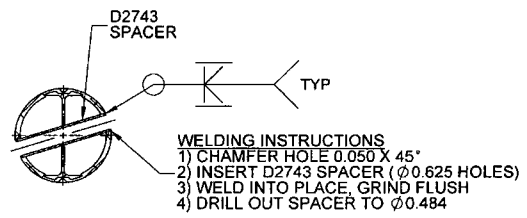
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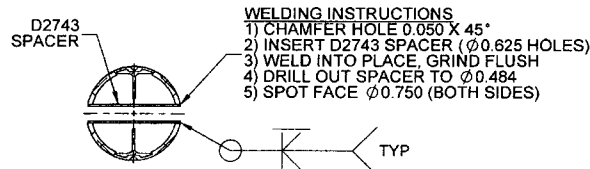
77757



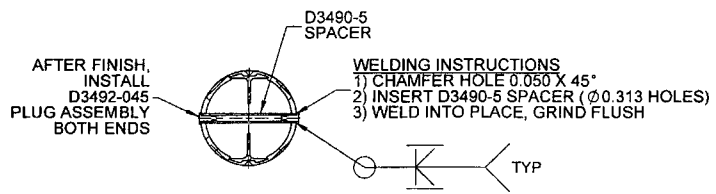
**D2750-044 350 SKIDTUBE ASSEMBLY, RH**



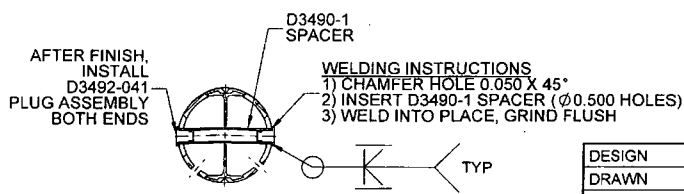
**SECTION BB-BB**  
SCALE 3X, 4 PL



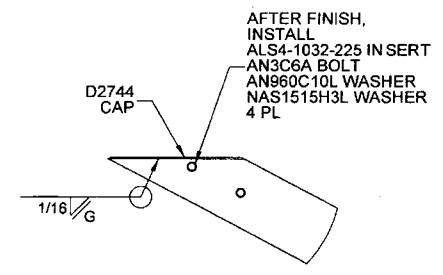
**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION BC-BC**  
SCALE 3X, 4 PL



**SECTION BE-BE**  
SCALE 3X, 4 PL



**DETAIL BA**  
SCALE 2X

DESIGN	REV	<b>DART AEROSPACE USA, INC.</b>	
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 11 OF 11
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 279

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 77362  
Part number: D 350 636 012  
Description: 350 skid tube  
Welding Process: Tig ☒ Mig ☐  
Base material: aluminum  
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐  
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐  
Undercut: pass ☒ fail ☐  
Pin holes: pass ☒ fail ☐  
Overlap (cold lap): pass ☒ fail ☐  
Porosity (surface): pass ☒ fail ☐  
Coloration: pass ☒ fail ☐

Qualifier Pat Lewis Date of Test Coupon 11.12.22

Welder Barclay Elliott Date of Test Coupon 11.12.22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld